

79564

January-27-12 12:53:35 PM

N900040100

Setup Start *NS1*

Stop. ***NS2***

300

300

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

Rev B1

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Machine as per folio FA214 on cobra machine.

70 12.2-14 300 0

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memò

0.00

Quality Control

20 12. 2. 14 300 /

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

ack 12/02/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79564

79564

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Item ID: D2649 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cross Bolt Spacer
 Start Date: 27/01/2012 Start Qty: 300.00 ***300*** Cust Item ID:
 Required Date: 10/02/2012 Req'd Qty: 300.00 ***300*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125		0.00							
125									
Skidtubes	Memo	0.00							
Skidtubes	1- clean crossbolt spacer with ultra brighth aluminum cleaner before storing.								
130	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging	***STOCK IN SKIDTUBE CELL***								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

332 332 12-02-28

300 332 CF 12-2-22 12-2-28

12/4/15

12-04-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 79564

79564

Parent Item: D2649

D2649

Parent Item Name: Cross Bolt Spacer

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 300.00

Required Qty: 300.00

Comments: IPP F02.03.26Added turning on CobraNG IPP Rev:G 10.05.11
added cleaning DD verified :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.058		Purchased	No			100	f	350.4340	0.2833	89.46316			
M6061T6T0 375W 058									**	78	12-2-14		

6061-T6 RD Tube .375 x.058W

Location	Loc Qty	Loc Code
MAT014	350.434	
116920	0.578	
119087	13.685	
119376	270	
119644	0.171	
119678	66	

M120634 X 50.100'
120 633

39.363

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

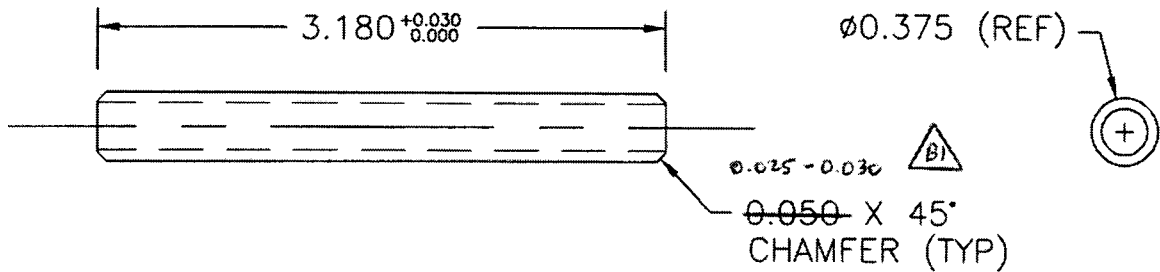
NOTE: Date & initial all entries



DESIGN <i>DK</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DK</i>	APPROVED <i>BW</i>	DRAWING NO. D2649	REV. B SHEET 1 OF 1
DATE 98.01.14		TITLE CROSS BOLT SPACER	SCALE 1:1
A	97.03.25	NEW ISSUE.	
B	98.01.14	3.180 WAS 3.230, ADD CHAMFER	
B1	<i># CP</i> 02.06.13	REDUCE CHAMFER PER TSR 1296.	

RELEASED
98.01.20 DS

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
NO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 79564 H.C.
12/01/27



MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
0.375 DIA 0.058 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		$ \begin{array}{r} 28 \\ 27 \\ \hline 57 \\ 5 \\ \hline 172 \\ 171 \\ \hline \end{array} $						
		$ \begin{array}{r} 293 \\ 57 \\ 57 \\ \hline 114 \\ 121 \\ \hline 235 \end{array} $						

NOTE: Date & initial all entries